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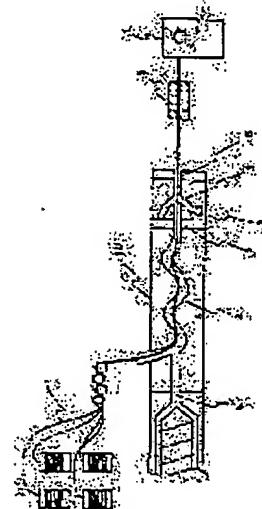
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(54) LONG FIBER REINFORCED THERMOPLASTIC RESIN COMPOSITION AND ITS MANUFACTURE

(57) Abstract:

PURPOSE: To manufacture a long fiber reinforced resin composition of good fabrication properties with little hairiness by impregnating a fiber bundle for reinforcing with a first molten thermoplastic material by means of a crosshead, coating its surface with a second molten thermoplastic material and shaping the same through a shaping die.

CONSTITUTION: A continuous fiber bundle 1 is provided, and high melting point fiber or the like, for example, glass fiber, carbon fiber, metallic fiber, aromatic polyamide fiber or the like, can be used as the kind of the fiber for reinforcing. As the shape of the fiber bundle, a roving-shaped fiber bundle is preferred from the viewpoint of easy handling. The fiber bundle 1 for reinforcing is guided to a crosshead 10, impregnated with a first molten thermoplastic resin material fed from a feeding section 8 and shaped by a shaping die 3, and then the surface of the impregnated fiber bundle is coated with a second molten thermoplastic material fed from a feeding section 9 and the bundle is shaped by a shaping die 5. It is preferable to use the second thermoplastic resin at the ratio of 1 - 50 pts. wt. to 99 - 50 pts. wt. of the first



thermoplastic resin, and the generation of hairiness is controlled to a large extent by said ratio.

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